

Date: Tuesday, 07/04/2009 3:21:57 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LOWER BLADE SUPPORT AND COVER ASSEMBLY	
Job Number :	47055			
Estimate Number :	13521			
P.O. Number :		Part Number :	PB674300123	
This Issue :	07/04/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	B6743001 P.10	
First Issue :	07/04/2009	Project Number :	N/A	
Previous Run :	45035	Drawing Revision :	B1	
		Material :		
Written By :		Due Date :	25/04/2009	Qty: 2 Um: Each
Checked & Approved By :	MF 09-04-08			
Comment :	Est Rev:A 08-07-25 new issue DD verified by:ec			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	MS27039110	Screw
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s) Screw batch: M110704 SAD 09-05-03	
✓ 2.0	NAS1149F0316P	WASHER
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s) WASHER batch: M111117 SAD 09-05-03	
✓ 3.0	PB674300179	Lower Blade Support Ass'y
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Lower Blade Support Ass'y batch: 47063 SAD 09-05-03	
✓ 4.0	PB674300183	PB67-43001-83
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) PB67-43001-83 batch: B47092 SAD 09-05-03	
✓ 5.0	PB6743001181	Cover Plate
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Cover Plate batch: B46056 SAD 09-05-03	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.05.01	5.1	ADD AN960-D10 (QTY.12) INSTALL 2/SCREWS BETWEEN COVER AND SUPPORT. B# 110985	SAD	09-05-01	24	LB 09-05-01	S 02/05/04	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOWER BLADE SUPPORT AND COVER ASSEMBLY

Job Number: 47055

Part Number: PB674300123

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Assemble as per dwg PB67-43001

SAD 09-05-03 (2)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SAD 09/05/04 (2)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST431

SS 09/05/04 (X2)

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/05/04

Job Completion



MF 09-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

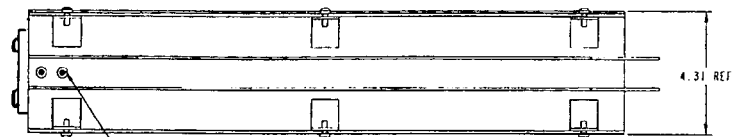
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



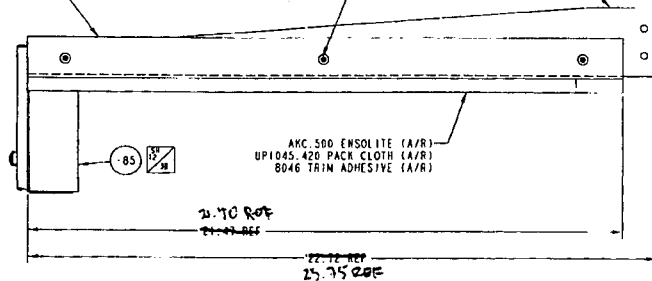
Ø.250 THRU -.173
MATCH DRILL WITH HOLE
PATTERN OF -.75
MS27039-1-10 SCREW
NAS1149F0316P WASHER
2 PLACES

MATCH DRILL COVER TO HOLES IN
ANGLE BRACKETS. ATTACH USING
MS27039-1-10 SCREW
NAS1149F0316P WASHER
6 PL (3 PL OPP)

Ø.173
P
K

Ø.75
P
K

C



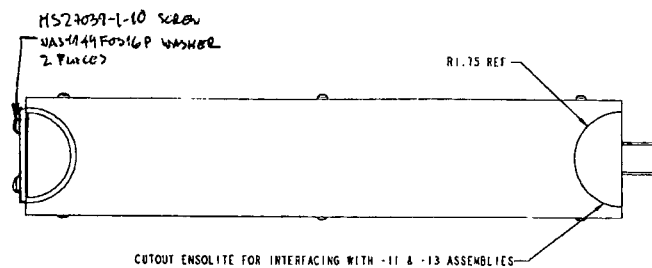
AKC 500 ENSOLITE (A/R)
UP1045 420 PACK CLOTH (A/R)
8046 TRIM ADHESIVE (A/R)

21.70 REF

25.75 REF

Ø.85
P
K

B



MS27039-1-10 SCREW
NAS1149F0316P WASHER
2 PLACES

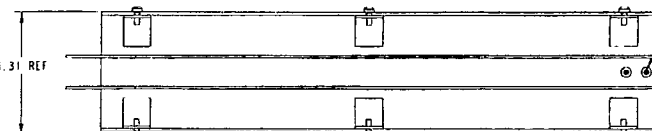
11.75 REF

CUTOUT ENSOLITE FOR INTERFACING WITH -11 & -13 ASSEMBLIES

A

② -21 UPPER BLADE SUPPORT AND COVER ASSEMBLY P K
SCALE 0.500

4.31 REF

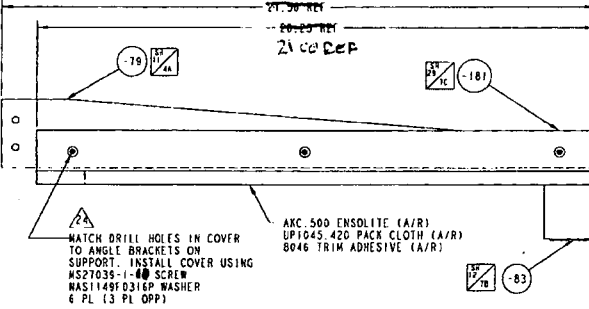


Ø.250 THRU -.181
MATCH DRILL -181 WITH
EXISTING HOLE PATTERN
OF -.75
MS27039-1-10 SCREW
NAS1149F0316P WASHER
2 PLACES

24.23 REF

21.50 REF

21.00 REF



MATCH DRILL HOLES IN COVER
TO ANGLE BRACKETS ON
SUPPORT. INSTALL COVER USING
MS27039-1-10 SCREW
NAS1149F0316P WASHER
6 PL (3 PL OPP)

AKC 500 ENSOLITE (A/R)
UP1045 420 PACK CLOTH (A/R)
8046 TRIM ADHESIVE (A/R)

Ø.181
P
K

Ø.85
P
K

D

C

B

A

② -23 LOWER BLADE SUPPORT AND COVER ASSEMBLY P K
SCALE 0.500

#47055

RELEASED
JAN 16 1970

PREMIER AVIATION, INC.
9800 Aviation Parkway, Grand Prairie, Texas 75050
DLOSUV8 867-43001
SCALE: 10 x 45

ORIGINAL

8 7 6 5 4 3 2 1